

SPL4

Dart Aerospace Ltd.

Date: Wednesday, 10/10/2007 11:03:43 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
 Job Number : 35082 -2
 Estimate Number : 11227
 P.O. Number :
 This Issue : 10/10/2007 S.O. No. :
 Prsht Rev. : NC
 First Issue : 11 Type : R&D THERMOFORMING
 Previous Run : 33897

Drawing Name : FLOOR PROCTOR FWD LH

Part Number : D32811
 Drawing Number : D3281 REV B
 Project Number : N/A
 Drawing Revision : B
 Material : C 68
 Due Date : 11/2/2007

UNDER REVIEW
 OK TO PRODUCE
 07-00-12

08-01-07

Qty: 20 Um: Each

Written By :
 Checked & Approved By :
 Comment : Est Rev. A. 04.07.01 New issue KJ/JLM
 Est. Rev B. 07.16.2007 Thermoform in house DL



Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 F6002 701

lexan black



Comment: Qty.: 4.3600 sf(s)/Unit Total : 87.2000 sf(s)
 lexan black .125"

Material Batch # M106957

2.0 HAND FINISH TH

HAND FINISHING THERMOFORMING



Comment: HAND FINISHING THERMOFORMING

1) Cut Blanks

BB 08/01/30

3.0 THERMOFORMING

THERMOFORMING MACHINE



Comment: THERMOFORMING MACHINE

Thermoform as per Dwg. D32811 and Folio FTA 011

Dwg. Rev. D3281
 Folio Rev.

BB 08/02/01

X 910

4.0 QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

BB 08/02/01 X 9

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOOR PROTECTOR FWD LH

Job Number: 35082

Part Number: D32811

Job Number:



Seq. #:

Machine Or Operation:

Description:

5.0

HAND FINISH TH

HAND FINISHING THERMOFORMING



Comment: HAND FINISHING THERMOFORMING

1) Trim to Finished Dimensions

BB 08/01/30 X1
BB 08/02/03 X8 (9)

6.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

1) Check Surface finish for undesired marks, voids, dimples etc.

2) Check dimensions to ensure conformity to drawing tolerances.

BB 08/01/30 X1
BB 08/02/03 X8 (9)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/02/04 (9)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

267 8/2/5 SP (9)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

(9)
2008/02/07

Job Completion



2008/2/06 (9) W

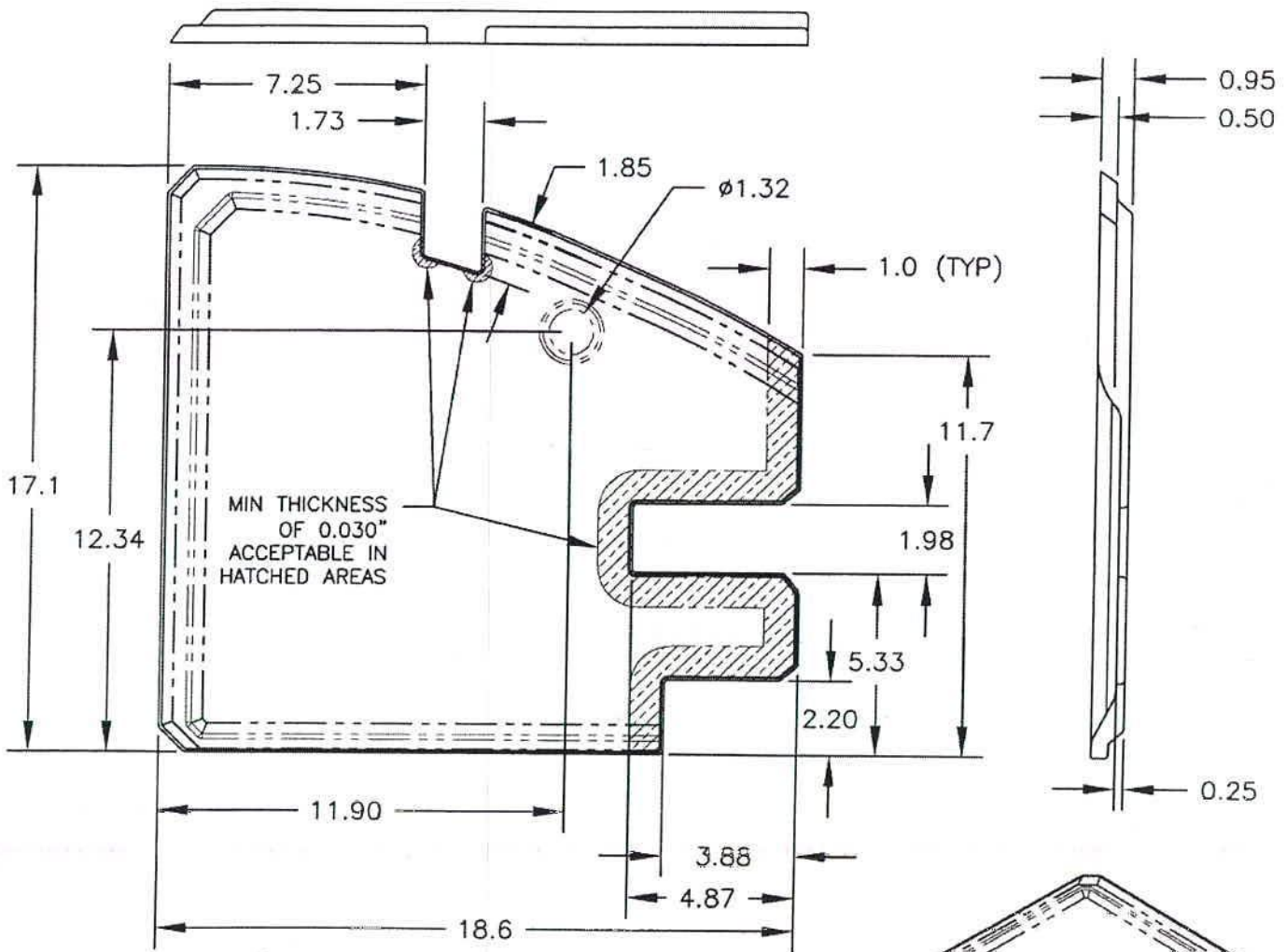
POSITIVE RECALL

EFFECTIVE 07/10/07 AUTH

RELEASED 07/10/07 DATE 08/01/04

DART

| | | | | | |
|---------|----------|---------------------------------|-----------------|-----------------------------|--------------|
| DESIGN | CP | DRAWN BY | CP | DART AEROSPACE LTD | REV. B |
| | | | | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | HH | APPROVED | HH | DRAWING NO. D3281 | SHEET 1 OF 3 |
| DATE | 05.11.25 | TITLE | FLOOR PROTECTOR | SCALE | 1:5 |
| A | 04.05.03 | NEW ISSUE | | | |
| B | 05.11.25 | NOW LEXAN; DIMS AS MANUFACTURED | | | |

**RELEASED**
05.12.01**UNDER REVIEW**07.10.05 LE
OK TO MANUFACTURE
AND SHIPSHOP COPY
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WITHOUT NOTICE
WORK ORDER

NO. _____

D3281-1 FLOOR PROTECTOR. FWD LH

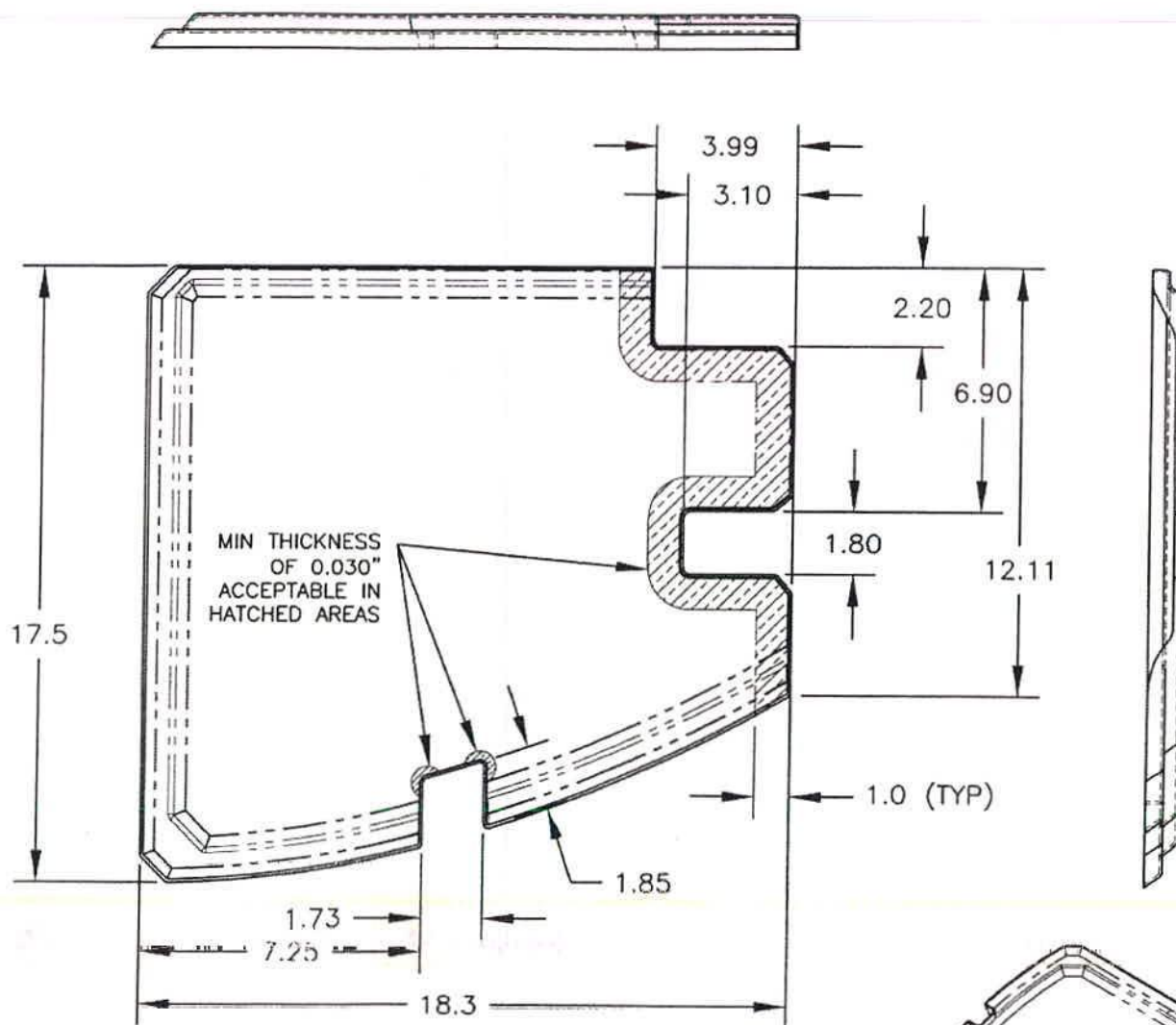
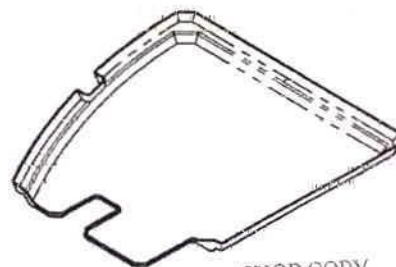
- 1) THERMOFORM D3281-1 USING MOLD D3281-1T1, TRIM USING D3281-1T2
- 2) MATERIAL: LEXAN F6006 BLACK No.700, 0.125 THICK
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) MIN. THICKNESS AFTER FORMING IS 0.080" EXCEPT AS SHOWN

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| CHECKED <i>HL</i> | APPROVED <i>HL</i> | DRAWING NO. D3281 | REV. B SHEET 2 OF 3 |
| DATE 05.11.25 | TITLE FLOOR PROTECTOR | SCALE 1:5 | |

**RELEASED**
05.12.01 *HL***UNDER REVIEW**07.10.05 LE
OK TO MANUFACTURE
AND SHIP**D3281-2 FLOOR PROTECTOR, FWD RH**

- 1) THERMOFORM D3281-2 USING MOLD D3281-2T1, TRIM USING D3281-2T2
- 2) MATERIAL: LEXAN F6006 BLACK No.700, 0.125 THICK
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) MIN. THICKNESS AFTER FORMING IS 0.080" EXCEPT AS SHOWN

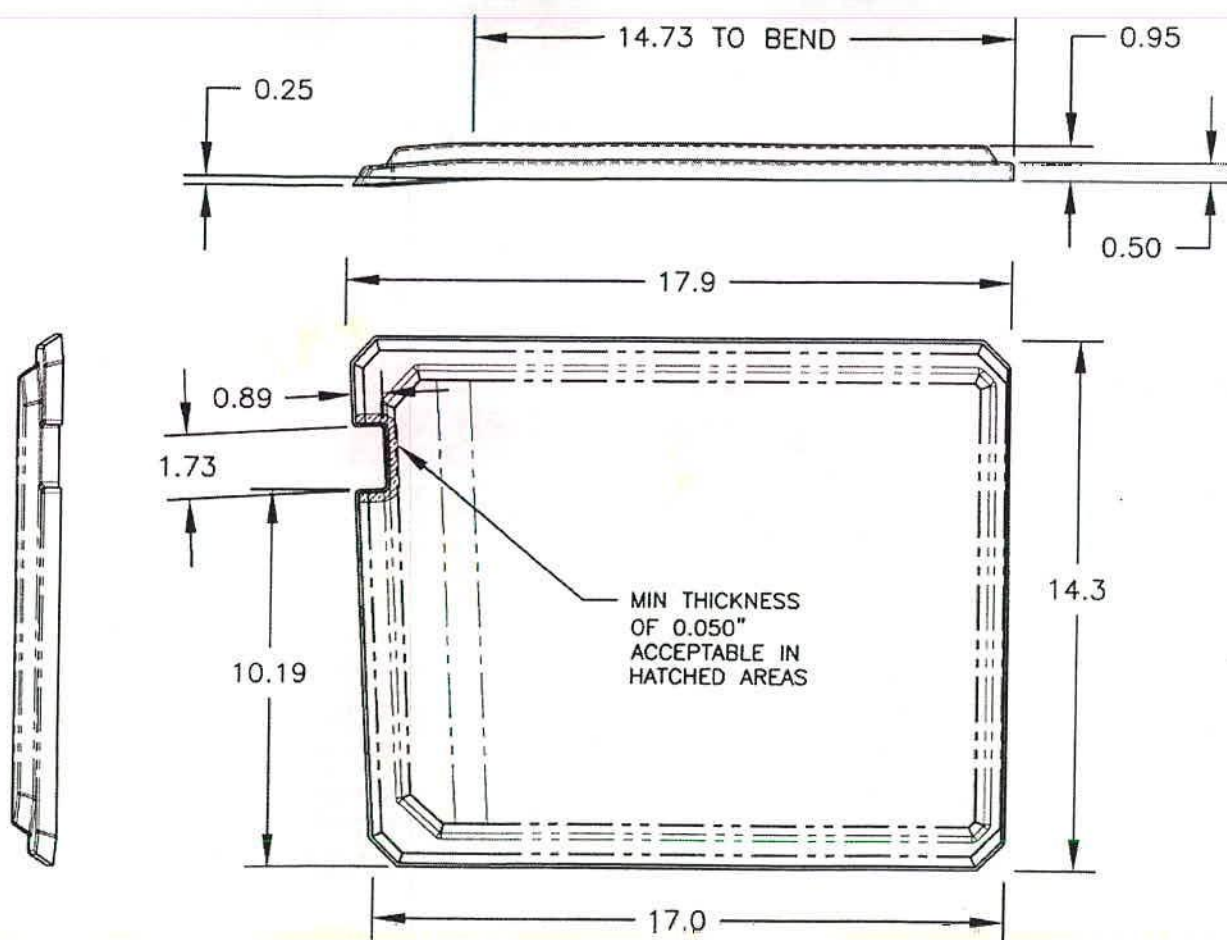
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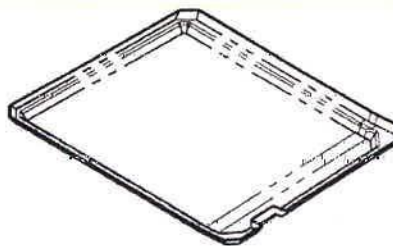
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| CHECKED <i>[Signature]</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D3281 | REV. B SHEET 3 OF 3 |
| DATE 05.11.25 | | TITLE FLOOR PROTECTOR | SCALE 1:5 |

**RELEASED**
05.2.01. *[Signature]***UNDER REVIEW**

07.10.05 LE

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AND SHIP

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WITHOUT NOTICE
WORK ORDER
NO. _____

D3281-3 FLOOR PROTECTOR, AFT LH (SHOWN)**D3281-4 FLOOR PROTECTOR, AFT RH (OPPOSITE)**

- 1) THERMOFORM D3281-3 USING MOLD D3281-3T1, TRIM USING D3281-3T2
THERMOFORM D3281-4 USING MOLD D3281-4T1, TRIM USING D3281-4T2
- 2) MATERIAL: LEXAN F6006 BLACK No.700, 0.125 THICK
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) MIN. THICKNESS AFTER FORMING IS 0.080" EXCEPT AS SHOWN

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| | | |
|---|--------|----------------------|
| DART AEROSPACE LTD | | Work Order: 35082 |
| Description: R44 Floor Protector FWD LH | | Part Number: D3281-1 |
| Inspection Dwg: D3281 | Rev: B | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

THERMOFORMING SECTION

| Description | Accept | Reject | Method of Inspection | Comments |
|---|--------|--------|----------------------|----------|
| Inside Radii less than 3/16" 60 / No 60 | BB | | | |
| Shape Definition | BB | | | |
| Texture Retention | BB | | | |
| Material imperfections such as bumps, cracks, voids, scratching | BB | | | |

| | |
|-----------------|----------------|
| Measured by: BB | Date: 08/02/01 |
|-----------------|----------------|

TRIMMING SECTION

| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|-----------|------------------|--------|--------|----------------------|----------|
| 18.6" | ± .100" | 18.65 | BB | | | |
| 17.1" | ± .100" | 17.15 | BB | | | |
| 11.7" | ± .100" | 11.71 | BB | | | |
| 0.95" | ± .030" | .979 | BB | | | |
| 0.25" | ± .030" | .266 | BB | | | |
| 7.25" | ± .030" | 7.245 | BB | | | |
| 1.73" | ± .030" | 1.734 | BB | | | |
| 1.98" | ± .030" | 1.985 | BB | | | |
| | | | | | | |
| | | | | | | |
| | | | | | | |

| | |
|-------------------------|----------------|
| Measured by: BB | Date: |
| Audited by: [Signature] | Date: 08.02.01 |
| Prototype Approval: | Date: |

| Rev | Date | Change | Revised by | Approved |
|-----|------|-----------|------------|----------|
| A | | New Issue | KJ/DL | |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: LD Date: 08/02/07
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|----------|------|--|--------------------------------|--|--------------------------------|--------------------------------|--------------------------------|--------------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| 08/02/04 | 3D | one Part scrap on Hemo form. over heated the sheet. R.C. Hamman error | <i>[Signature]</i> 08/02/04 | Scrap and destroy No Replac Qty 10 | <i>[Signature]</i> 08/02/04 | <i>[Signature]</i> 08/02/04 | <i>[Signature]</i> 08/02/04 | <i>[Signature]</i> 08/02/04 |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries